

Custom Roll Forming: 2002

Issued September 2004

EC02-311-332114

2002 Economic Census

Manufacturing

Industry Series



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U.S. Department of Commerce
Economics and Statistics Administration
U.S. CENSUS BUREAU



Table 1. Historical Statistics for the Industry: 2002 and Earlier Years

[Data based on the 2002 Economic Census and the 2002 Annual Survey of Manufactures (ASM). For information on confidentiality protection, sampling error, nonsampling error, and explanation of terms, see note at end of table. For meaning of abbreviations and symbols, see introductory text]

Industry and year ¹	Com- panies ²	All estab- lish- ments ³	All employees		Production workers			Value added (\$1,000)	Total cost of materials (\$1,000)	Total value of shipments (\$1,000)	Total capital expendi- tures (\$1,000)	
			Number ⁴	Payroll (\$1,000)	Number ⁴	Hours (1,000)	Wages (\$1,000)					
332114, Custom roll forming	2002..	373	446	17 227	638 369	12 892	26 629	403 872	1 735 533	2 318 125	4 035 142	155 078
	2001..	N	N	15 468	529 900	11 549	23 002	330 772	1 357 346	2 104 025	3 471 283	93 979
	2000..	N	N	16 240	557 869	12 150	24 665	350 428	1 421 158	2 382 813	3 783 951	88 717
	1999..	N	N	15 978	541 722	11 880	24 268	337 901	1 431 408	2 181 814	3 624 374	69 374
	1998..	N	N	15 538	542 067	11 077	23 779	332 709	1 304 404	2 180 582	3 483 675	52 554
	1997..	360	404	15 852	522 950	11 370	23 765	314 799	1 343 729	1 992 247	3 301 907	58 607

¹Statistics presented for years ending in 2 and 7 are census data. Interim census years are derived in a representative sample of manufacturing establishments canvassed in the Annual Survey of Manufactures (ASM).

²For the census, a company is defined as a business organization consisting of one establishment or more under common ownership or control.

³Includes establishments with payroll at any time during the year.

⁴Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

Note: The data in this table are based on the 2002 Economic Census and the 2002 Annual Survey of Manufactures (ASM). To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain sampling errors and nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 2. Industry Statistics for Selected States: 2002

[States that are a disclosure or with less than 100 employees are not shown. Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, explanation of terms, and geographical definitions, see note at end of table. For information on geographic areas followed by *, see Appendix D. For meaning of abbreviations and symbols, see introductory text]

Industry and geographic area	E ¹	All establishments ²		All employees		Production workers			Value added (\$1,000)	Total cost of materials (\$1,000)	Total value of shipments (\$1,000)	Total capital expenditures (\$1,000)
		Total	With 20 employees or more	Number ³	Payroll (\$1,000)	Number ³	Hours (1,000)	Wages (\$1,000)				
332114, Custom roll forming												
United States	1	446	232	17 227	638 369	12 892	26 629	403 872	1 735 533	2 318 125	4 035 142	155 078
California	1	49	23	1 356	51 835	956	1 967	30 350	129 740	136 855	262 971	8 570
Florida	—	18	9	748	29 210	587	1 189	18 853	132 893	88 945	224 356	6 841
Illinois	—	30	18	1 725	62 691	1 331	2 860	42 213	155 769	165 801	313 579	8 674
Indiana	2	18	10	774	24 320	541	1 101	16 566	72 988	172 116	244 257	14 302
Massachusetts	5	7	4	122	4 359	102	216	3 218	17 358	32 662	48 457	2 833
Michigan	2	24	12	560	24 998	372	790	12 400	44 486	50 268	90 227	3 507
Minnesota	—	11	4	242	8 366	180	408	5 403	17 966	25 739	43 617	856
Missouri	—	10	4	199	7 575	132	268	4 224	7 463	46 081	53 426	1 945
New York	1	15	3	206	7 511	153	323	4 466	17 114	13 592	30 710	1 692
Ohio	—	35	23	2 735	111 037	2 103	4 468	74 000	348 187	630 040	982 607	27 958
Oregon	—	6	4	239	9 941	183	407	6 336	18 298	9 763	27 999	499
Pennsylvania	1	25	14	877	32 681	643	1 309	20 485	95 672	56 600	150 381	3 903
South Carolina	3	8	4	157	6 181	109	237	3 170	22 148	38 986	59 801	13 230
Washington	4	13	4	241	7 503	163	266	4 402	16 230	31 669	46 895	2 232

¹Some payroll and sales data for small single-establishment companies with up to 20 employees (cutoff varied by industry) were obtained from administrative records of other government agencies rather than from census report forms. These data were then used in conjunction with industry averages to estimate statistics for these small establishments. This technique was also used for a small number of other establishments whose reports were not received at the time data were tabulated. The following symbols are shown where estimated data account for 10 percent or more of the figures shown: 1–10 to 19 percent; 2–20 to 29 percent; 3–30 to 39 percent; 4–40 to 49 percent; 5–50 to 59 percent; 6–60 to 69 percent; 7–70 to 79 percent; 8–80 to 89 percent; 9–90 percent or more.

²Includes establishments with payroll at any time during the year.

³Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

Note: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C. For geographical definitions, see Appendix D.

Table 3. Detailed Statistics by Industry: 2002

[Data based on the 2002 Economic Census and the 2002 Annual Survey of Manufactures (ASM). For information on confidentiality protection, sampling error, nonsampling error, and explanation of terms, see note 2 at end of table. For meaning of abbreviations and symbols, see introductory text]

Item	Value
332114, Custom roll forming	
Companies ¹	number.. 373
All establishments ²	number.. 446
Establishments with 1 to 19 employees	number.. 214
Establishments with 20 to 99 employees	number.. 195
Establishments with 100 employees or more	number.. 37
All employees ³	number.. 17 227
Total compensation	\$1,000.. 778 020
Annual payroll	\$1,000.. 638 369
Total fringe benefits	\$1,000.. 139 651
Production workers, average for year	number.. 12 892
Production workers on March 12	number.. 12 705
Production workers on May 12	number.. 12 857
Production workers on August 12	number.. 13 092
Production workers on November 12	number.. 12 852
Production worker hours	1,000.. 26 629
Production worker wages	\$1,000.. 403 872
Total cost of materials	\$1,000.. 2 318 125
Materials, parts, containers, packaging, etc., used	\$1,000.. 2 070 086
Resales	\$1,000.. 112 631
Purchased fuels	\$1,000.. 22 658
Purchased electricity	\$1,000.. 28 546
Contract work	\$1,000.. 84 204
Quantity of electricity purchased for heat and power	1,000 kWh.. 432 736
Quantity of electricity generated less sold for heat and power	1,000 kWh.. S
Total value of shipments	\$1,000.. 4 035 142
Primary products value of shipments	\$1,000.. 3 740 874
Secondary products value of shipments	\$1,000.. 115 824
Total miscellaneous receipts	\$1,000.. 178 444
Value of resales	\$1,000.. 136 775
Contract receipts	\$1,000.. 18 813
Other miscellaneous receipts	\$1,000.. 22 856
Primary products specialization ratio	percent.. 97
Value of primary products shipments made in all industries	\$1,000.. 3 981 614
Value of primary products shipments made in this industry	\$1,000.. 3 740 874
Value of primary products shipments made in other industries	\$1,000.. 240 740
Coverage ratio	percent.. 94
Value added	\$1,000.. 1 735 533
Total inventories, beginning of year	\$1,000.. 532 124
Finished goods inventories	\$1,000.. 169 348
Work-in-process inventories	\$1,000.. 98 861
Materials and supplies inventories	\$1,000.. 263 915
Total inventories, end of year	\$1,000.. 559 008
Finished goods inventories	\$1,000.. 185 953
Work-in-process inventories	\$1,000.. 100 772
Materials and supplies inventories	\$1,000.. 272 283
Gross value of depreciable assets (acquisition costs) at beginning of year	\$1,000.. 1 911 707
Total capital expenditures (new and used)	\$1,000.. 155 078
Buildings and other structures (new and used)	\$1,000.. 29 553
Machinery and equipment (new and used)	\$1,000.. 125 525
Automobiles, trucks, etc., for highway use	\$1,000.. 7 477
Computers and peripheral data processing equipment	\$1,000.. 10 857
All other expenditures for machinery and equipment	\$1,000.. 107 191
Total retirements	\$1,000.. 69 560
Gross value of depreciable assets at end of year	\$1,000.. 1 997 225
Depreciation charges during year	\$1,000.. 145 691
Total rental payments	\$1,000.. 53 445
Buildings and other structures	\$1,000.. 33 013
Machinery and equipment	\$1,000.. 20 432
Total other expenses ⁴	\$1,000.. 342 579
Response coverage ratio ⁵	percent.. 78
Repair and maintenance services of buildings and/or machinery ⁴	\$1,000.. 40 688
Communications services ⁴	\$1,000.. 5 392
Legal services ⁴	\$1,000.. 4 006
Accounting, auditing, and bookkeeping services ⁴	\$1,000.. 4 069
Advertising and promotional services ⁴	\$1,000.. 4 975
Expensed computer hardware and supplies and purchased computer services ⁴	\$1,000.. 5 976
Refuse removal (including hazardous waste) services ⁴	\$1,000.. 3 617
Management consulting and administrative services ⁴	\$1,000.. 7 382
Taxes and license fees ⁴	\$1,000.. 12 812
All other expenses ⁴	\$1,000.. 253 662

¹For the census, a company is defined as a business organization consisting of one establishment or more under common ownership or control.

²Includes establishments with payroll at any time during the year.

³Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

⁴Based on Annual Survey of Manufactures (ASM) sample data.

⁵A response coverage ratio is derived for this item by calculating the ratio of the weighted employment (establishment data multiplied by sample weight) for those Annual Survey of Manufactures (ASM) establishments that reported to the weighted total employment for all ASM establishments classified in this industry.

Note 1: The amounts shown for other expenses reflect only those services that establishments purchase from other companies.

Note 2: The data in this table are based on the 2002 Economic Census and the 2002 Annual Survey of Manufactures (ASM). To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain sampling errors and nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 4. Industry Statistics by Employment Size: 2002

[Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, and explanation of terms, see note at end of table. For meaning of abbreviations and symbols, see introductory text]

Employment size class	E ¹	All establishments ²	All employees		Production workers			Value added (\$1,000)	Total cost of materials (\$1,000)	Total value of shipments (\$1,000)	Total capital expenditures (\$1,000)
			Number ³	Payroll (\$1,000)	Number ³	Hours (1,000)	Wages (\$1,000)				
332114, Custom roll forming											
All establishments	1	446	17 227	638 369	12 892	26 629	403 872	1 735 533	2 318 125	4 035 142	155 078
Establishments with—											
1 to 4 employees	6	56	133	4 539	101	192	2 821	9 500	17 513	27 545	2 477
5 to 9 employees	4	56	387	15 288	292	590	9 706	34 098	42 137	75 539	3 241
10 to 19 employees	1	102	1 474	55 881	1 020	2 052	32 283	125 015	166 723	286 852	21 854
20 to 49 employees	2	135	4 232	158 589	3 114	6 389	96 874	435 234	543 509	978 026	39 175
50 to 99 employees	2	60	4 116	144 698	3 147	6 609	92 067	388 997	543 082	920 875	31 284
100 to 249 employees	—	31	5 007	184 513	3 821	7 653	123 134	552 485	618 498	1 170 004	46 805
250 to 499 employees	—	6	1 878	74 861	1 397	3 144	46 987	190 204	386 663	576 301	10 242
500 to 999 employees	—	—	—	—	—	—	—	—	—	—	—
1,000 to 2,499 employees	—	—	—	—	—	—	—	—	—	—	—
2,500 employees or more	—	—	—	—	—	—	—	—	—	—	—
Administrative records ⁴	9	71	307	10 819	238	477	6 856	18 025	38 153	56 179	3 424

¹Some payroll and sales data for small single-establishment companies with up to 20 employees (cutoff varied by industry) were obtained from administrative records of other government agencies rather than from census report forms. These data were then used in conjunction with industry averages to estimate statistics for these small establishments. This technique was also used for a small number of other establishments whose reports were not received at the time data were tabulated. The following symbols are shown where estimated data account for 10 percent or more of the figures shown: 1–10 to 19 percent; 2–20 to 29 percent; 3–30 to 39 percent; 4–40 to 49 percent; 5–50 to 59 percent; 6–60 to 69 percent; 7–70 to 79 percent; 8–80 to 89 percent; 9–90 percent or more.

²Includes establishments with payroll at any time during the year.

³Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

⁴Some payroll and sales data for small single-establishment companies with up to 20 employees (cutoff varied by industry) were obtained from administrative records of other government agencies rather than from census report forms. These data were then used in conjunction with industry averages to estimate statistics for these small establishments. Data are also included in respective size classes shown.

Note: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 5. Industry Statistics by Primary Product Class Specialization: 2002

[Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, and explanation of terms, see note at end of table. For meaning of abbreviations and symbols, see introductory text]

Industry or product class code	Industry or primary product class	All establishments ¹	All employees		Production workers			Value added (\$1,000)	Total cost of materials (\$1,000)	Total value of shipments (\$1,000)	Total capital expenditures (\$1,000)
			Number ²	Payroll (\$1,000)	Number ²	Hours (1,000)	Wages (\$1,000)				
332114	Custom roll forming	446	17 227	638 369	12 892	26 629	403 872	1 735 533	2 318 125	4 035 142	155 078
3321140	Custom roll form products	446	17 227	638 369	12 892	26 629	403 872	1 735 533	2 318 125	4 035 142	155 078

¹Includes establishments with payroll at any time during the year.

²Number of employees figures represent average number of production workers for pay period that includes the 12th of March, May, August, and November plus other employees for payroll period that includes the 12th of March.

Note: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 6a. **Products Statistics: 2002 and 1997**

[Includes quantity and value of products of this industry produced by (1) establishments classified in this industry (primary) and (2) establishments classified in other industries (secondary). Transfers of products of this industry from one establishment of a company to another establishment of the same company (interplant transfers) are also included. Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, and explanation of terms, see note 2 at end of table. For meaning of abbreviations and symbols, see introductory text]

Product code	Product	Number of companies with shipments of \$100,000 or more	Quantity of production for all purposes	Product shipments	
				Quantity	Value (\$1,000)
332114	Custom roll forming	2002.. N 1997.. N	X X	X X	3 981 614 3 455 053
3321140	Custom roll form products	2002.. N 1997.. N	X X	X X	3 981 614 3 455 053
33211401	Custom carbon steel roll form products	2002.. N 1997.. N	X X	X X	2 731 109 2 327 156
3321140101	Custom carbon steel roll form products	2002.. 220 1997.. 253	X X	X X	2 731 109 2 327 156
33211402	Custom stainless steel roll form products	2002.. N 1997.. N	X X	X X	283 694 233 724
3321140206	Custom stainless steel roll form products	2002.. 128 1997.. 137	X X	X X	283 694 233 724
33211403	Custom aluminum roll form products	2002.. N 1997.. N	X X	X X	327 993 274 130
3321140311	Custom aluminum roll form products	2002.. 72 1997.. 83	X X	X X	327 993 274 130
33211404	Other custom metal roll form products	2002.. N 1997.. N	X X	X X	303 193 245 474
3321140416	Other custom metal roll form products	2002.. 72 1997.. 70	X X	X X	303 193 245 474
3321140Y	Custom roll form products, nsk, total	2002.. N 1997.. N	X X	X X	335 625 374 569
3321140YWW	Custom roll form products, nsk, for nonadministrative-record establishments	2002.. N 1997.. N	X X	X X	283 866 338 945
3321140YWY	Custom roll form products, nsk, for administrative-record establishments	2002.. N 1997.. N	X X	X X	51 759 35 624

Note 1: For some establishments, data have been estimated from central unit values that are based on quantity-value relationships of reported data. The following symbols are used when percentage of each quantity figure estimated in this manner equals or exceeds 10 percent of published figure: p-10 to 19 percent estimated; q-20 to 29 percent estimated. If 30 percent or more is estimated, figure is replaced by S.

Note 2: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.

Table 6b. **Product Class Shipments for Selected States: 2002 and 1997**

[Not applicable for this report.]

Table 7. Materials Consumed by Kind: 2002 and 1997

[Includes quantity and cost of materials consumed or put into production by establishments classified only in this industry. Data based on the 2002 Economic Census. For information on confidentiality protection, nonsampling error, and explanation of terms, see note 2 at end of table. For meaning of abbreviations and symbols, see introductory text]

Material code	Material consumed	Quantity	Delivered cost (\$1,000)
332114	Custom roll forming		
00900001	Total materials2002..	X	2 070 086
1997..	X	1 794 421
33272203	Metal bolts, nuts, screws, washers, rivets, and other screw machine products2002..	X	48 899
1997..	X	20 013
33200095	Other fabricated metal products (excluding castings and forgings)2002..	X	74 262
1997..	X	34 684
33100035	Castings, rough and semifinished2002..	X	D
1997..	X	9 611
33210000	Forgings2002..	X	D
1997..	X	N
33120007	Steel bars, bar shapes, and plate (excluding castings, forgings, and fabricated metal products)2002..	X	135 248
1997..	X	191 886
33120016	Steel sheet and strip (including tinplate)2002..	X	331 971
1997..	X	N
33120069	Steel structural shapes (excluding castings, forgings, and fabricated metal products)2002..	X	84 293
1997..	X	60 697
33120036	All other steel shapes and forms (excluding castings, forgings, fabricated metal products, bars, bar shapes, plate, sheet, strip, and structural shapes), including concrete reinforcing bars2002..	X	424 139
1997..	X	N
33131500	Aluminum and aluminum-base alloy sheet, plate, foil, and welded tubing2002..	X	67 941
1997..	X	N
33100008	All other aluminum and aluminum-base alloy shapes and forms, including refinery shapes and extruded shapes (excluding castings and forgings)2002..	X	74 702
1997..	X	N
33100077	Other nonferrous shapes and forms (excluding castings, forgings, and fabricated metal products)2002..	X	73 224
1997..	X	N
32551002	Paints, varnishes, stains, lacquers, shellacs, japans, enamels, and allied product2002..	X	D
1997..	X	N
00970099	All other materials and components, parts, containers, and supplies2002..	X	437 637
1997..	X	1 294 606
00971000	Materials, ingredients, containers, and supplies, nsk2002..	X	268 704
1997..	X	182 924

Note 1: For some establishments, data have been estimated from central unit values that are based on quantity-value relationships of reported data. The following symbols are used when percentage of each quantity figure estimated in this manner equals or exceeds 10 percent of published figure: p-10 to 19 percent estimated; q-20 to 29 percent estimated. If 30 percent or more is estimated, figure is replaced by S.

Note 2: The data in this table are based on the 2002 Economic Census. To maintain confidentiality, the Census Bureau suppresses data to protect the identity of any business or individual. The census results in this table contain nonsampling errors. Data users who create their own estimates using data from American FactFinder tables should cite the Census Bureau as the source of the original data only. For explanation of terms, see Appendix A. For full technical documentation, see Appendix C.